

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022658**Date Inspected:** 16-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

WELDING:

Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 069683 perform Shielded Metal Arc Welding (SMAW), weld joint identified as AH3001-090; located On Orthotropic Box Girder (OBG) Side Plate to I-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. The Welding Repair Report (WRR) was B-WR20449. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Shen Jian Bo was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-4G (4F) FCM-Repair-1. See attached photo for further details.

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Segment 13AE

This QA Inspector observed ZPMC qualified welding personnel identified as 068924 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3011-008; located On Orthotropic Box Girder (OBG) Deck Plate to Deck Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhang Hai Feng . This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Zhan Hai Feng was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1. See attached photo for further details.

Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 047864 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3013P-081; located On Orthotropic Box Girder (OBG) X4369B to SP3102A CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Shen Jian Bo was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2213-TC-U4b-FCM-1.

Segment 12CW

This QA Inspector observed ZPMC qualified welding personnel identified as 203871 perform Flux Cored Arc Welding (FCAW), weld joint identified as BP3029-001-009; located On Orthotropic Box Girder (OBG) Bottom Plate to T-Rib Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Zhou Peng was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2132-ESAB.

Segment 12CW

This QA Inspector observed ZPMC qualified welding personnel identified as 066443 perform Shielded Metal Arc Welding (SMAW), weld joint identified as BP3027-001-032; located On Orthotropic Box Girder (OBG) Bottom Plate to T-rib Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Zhou Peng was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1

Segment 12CW

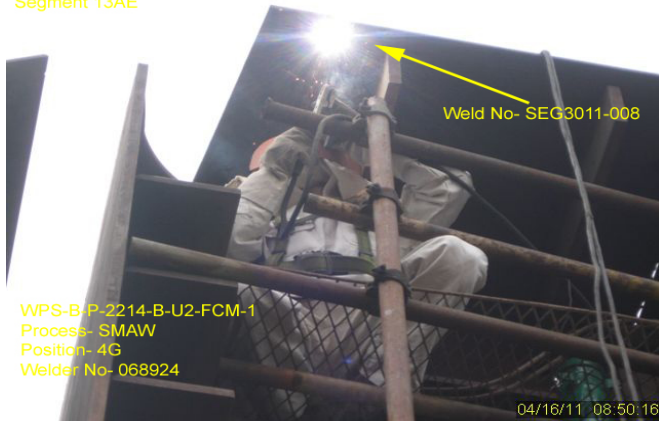
This QA Inspector observed ZPMC qualified welding personnel identified as 066398 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP3056-001-017; located On Orthotropic Box Girder (OBG) Side Plate to T-rib Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Zhou Peng was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

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Segment 13AE



Segment 13AW



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
